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D3914-041
Job Sheet 183909



3

Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/12/18	0.00	0.00	Start Up Large Fab-5		CC
100	Large Fab	1 pcs		10/12/18	0.00	6.67	Large Fab 1		CC
110	QC	1 pcs		10/12/18	0.00	0.00	QC9		
120	QC	1 pcs		10/12/18	0.00	0.00	QC5		
130	Powdercoat	1 pcs		10/12/18	0.00	0.40	Powdercoat4		BP 18-10-23
135	QC	1 pcs		10/12/18	0.00	0.00	QC3		REL 18-10-23
140	HandFinish	1 pcs		10/12/18	0.00	0.80	HandFinish3		18-10-23
150	QC	1 pcs		10/12/18	0.00	0.00	QC3		18-10-23
160	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea		10/12/18	0.00	0.00	QC21		OCT 24 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 138839. START: 10:05 O.V.T. 3:00 FINISH: 10:35.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097502
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5112316
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5113730
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5110937
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5110523
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5113739
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5064261
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5111126

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

90-Start up Operation

D2581	2	78	0
D3914-1	2	7	0
D3914-7	2	12	0
D4016-3	3	198	0
D4018-5	9	51	0
D4020-5	1	11	0
D4021-3	1	34	0
D4035-043	2	6	0

Part Specifications

Specifications could not be found.

Plex 9/28/18 11:35 AM Dart.lajeunesse.marie

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work

Work Order: _____	DISPOSITION		AGAINST DEPART
	Rework	☐	Skid-tube ☐ Cross tube ☐
Part No. _____	Scrap	☐	Machining ☐ Small Fab ☐
	Use-as-is	☐	Thermoforming ☐ Finishing ☐
NCR No. _____	Suspected Unapproved	☐	Large Fab ☐ Composite ☐

Date :	Step #:	QTY Effective :
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Description Work Order Deviation	Disposition

QC / QA Coordinator
Approval

Root Cause			FAULT CATEGORY			
Environment	☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
Design	☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
Doc/Data	☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
Equip/Tooling	☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
Handling/Pre	☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Material	☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
Internal Transport	☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
Tribal Knowledge	☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
LOA	☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
Substation	☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
Past Expiry Date	☐	☐ Manufacturing Process				
Misidentified	☐	☐ Past Due	☐ OTHER :			

Part: D3914-041
Job No: 183909
Serial No/Batch: S114790
Revision: AD
Inspector:
Exp Date:
Instructions: Various STC's

Date: 10/01/16



Container No: S114790

Part: D3914-041

Job No: 183909

Serial No/Batch: S114790
Revision: A/D

Revision: A/D
Inspector:

Exp Date:

Instructions: Various STC's

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